

STOCK

Work Order ID 135972

135972

Page 1

Item ID: D3574-5

Accept

N19000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 8/26/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/9/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: 54Dwg: 0150826 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
Debur if necessary

(2)

02/15/09/09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(2)

02/15/09/09

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(2)

DAS
38
9-89

SEP 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER :																																																																				

Work Order ID 135972

August 26, 2015 10:23:43 AM

135972

Page 2

Item ID: D3574-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 8/26/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/9/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Memo <i>N/A</i>	DAS 38 0.00							
Small Fab	Deburr if necessary.	9-89							
Small Fab									
140	QC5- Inspect part completeness to step on W/O	0.00							
140	Memo <i>N/A</i>	DAS 38 0.00							
QC		9-89							
Quality Control									
150	Identify as per dwg & Stock Location: <i>PP13 6348</i>	0.00							
150	Memo	0.00							
Packaging									
Packaging									

SEP 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																				
OTHER : _____																									

Work Order ID 135972***135972***

Page 3

Item ID: D3574-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cabin Floor Protector

Stop ***NS2***

Start Date: 8/26/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/9/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

— MLJ — SEP 10 2015 —SJA 20150910

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

August 26, 2015 10:23:52 AM

Page 1

Work Order ID: 135972

135972

Parent Item: D3574-5

D3574-5

Parent Item Name: Cabin Floor Protector

Start Date: 8/26/2015

Required Date: 9/9/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	913.2344		50.70588			
MI FXS 125-F60029-04									**	<i>Dec 15/09/09</i>			
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

MAT

567.2

m131705

567.2

MAT019

346.0344

m129759

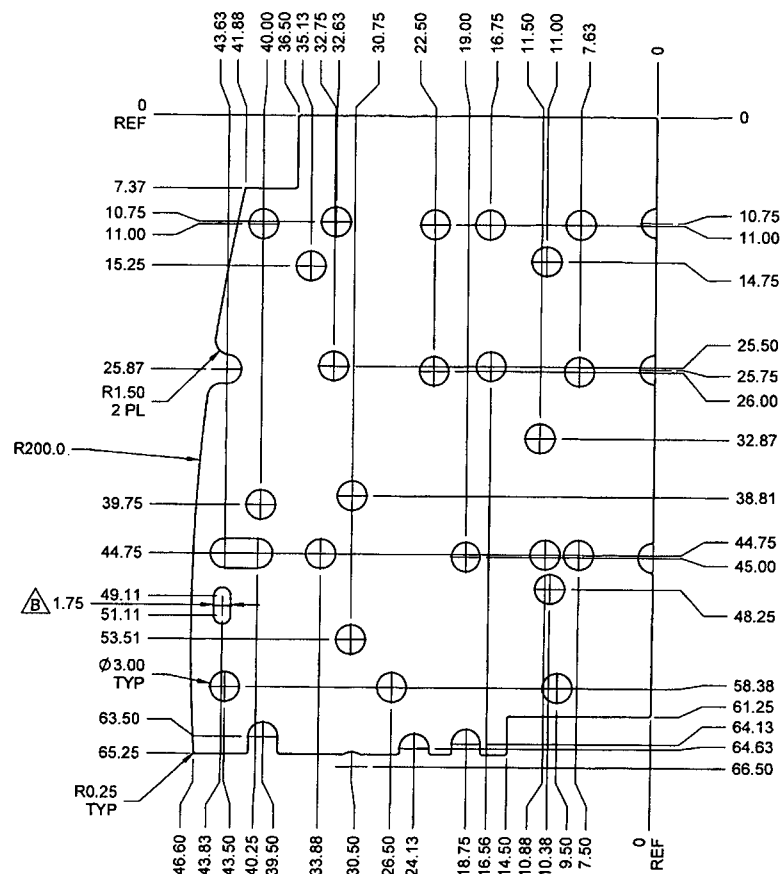
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m130209

292.701

133111

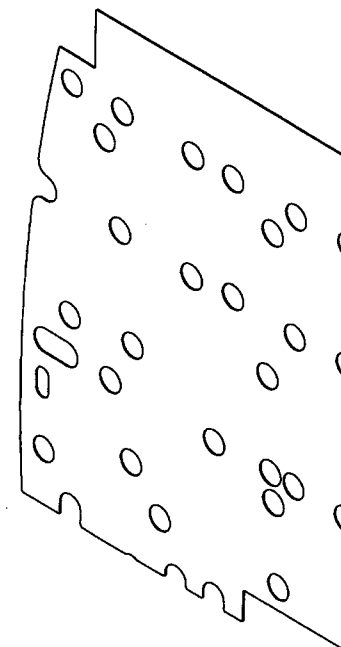
50



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



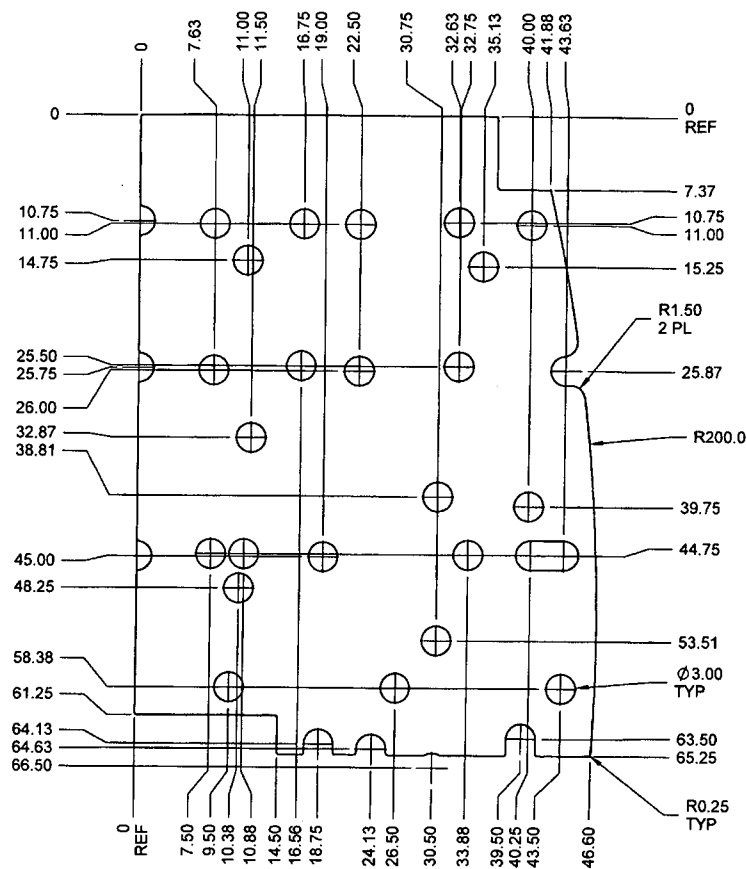
RELEASED
20150826

B	ADD CUT-OUT TO -1/-5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B
SHEET 1 OF 6
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

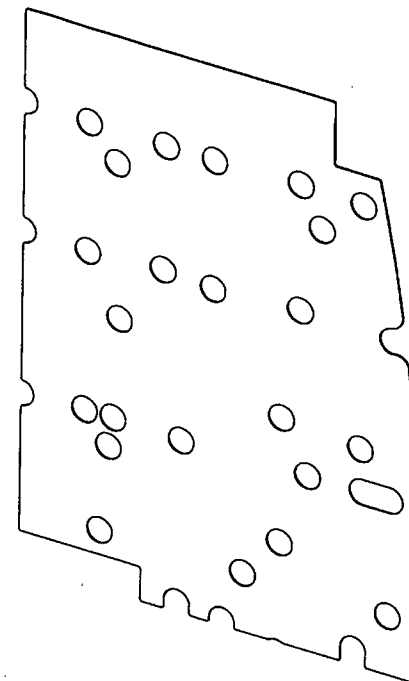
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D3574-2 CABIN FLOOR PROTECTOR

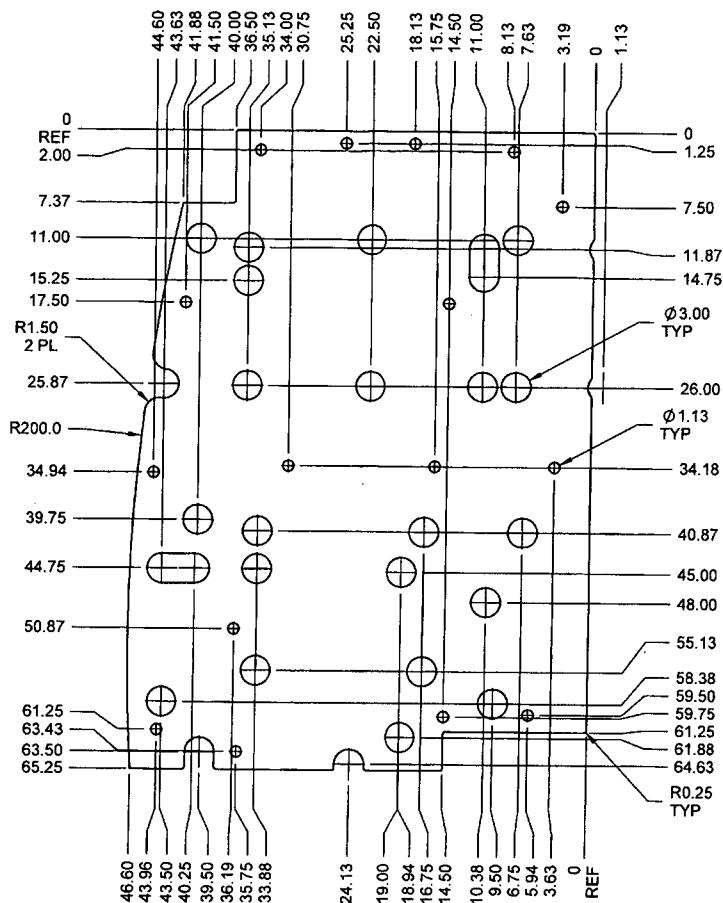
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



RELEASED
09/04/01/114

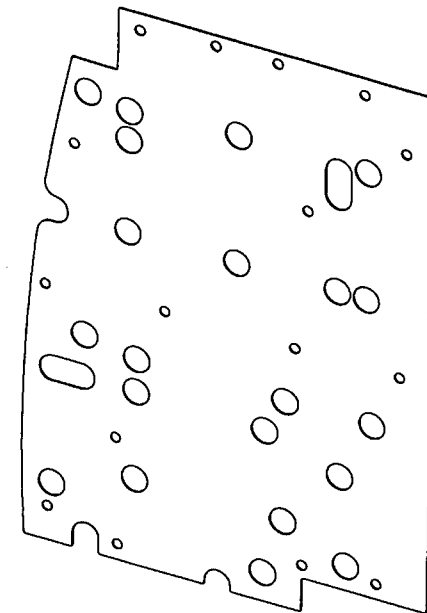
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3574-3 CABIN FLOOR PROTECTOR

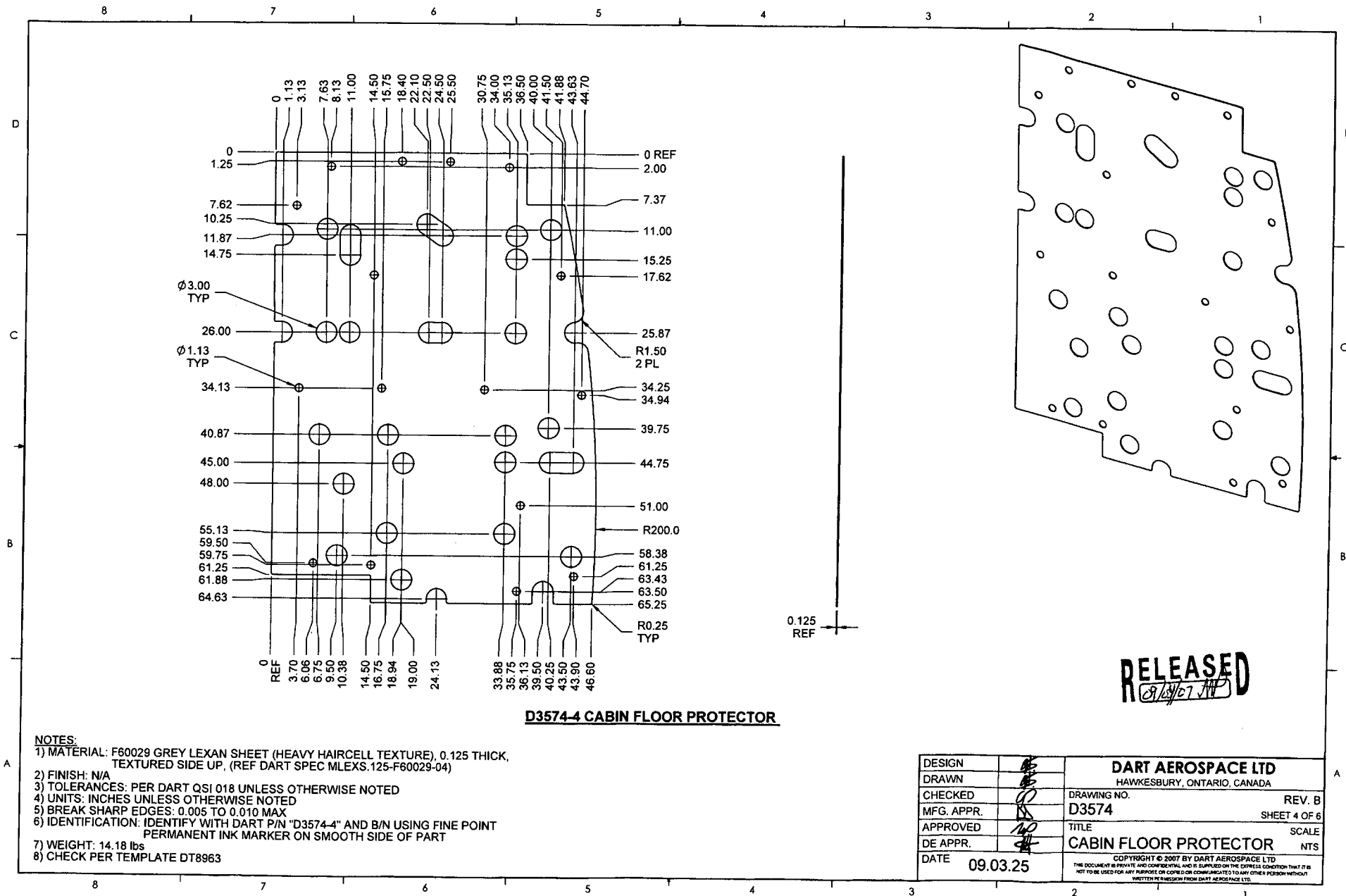
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

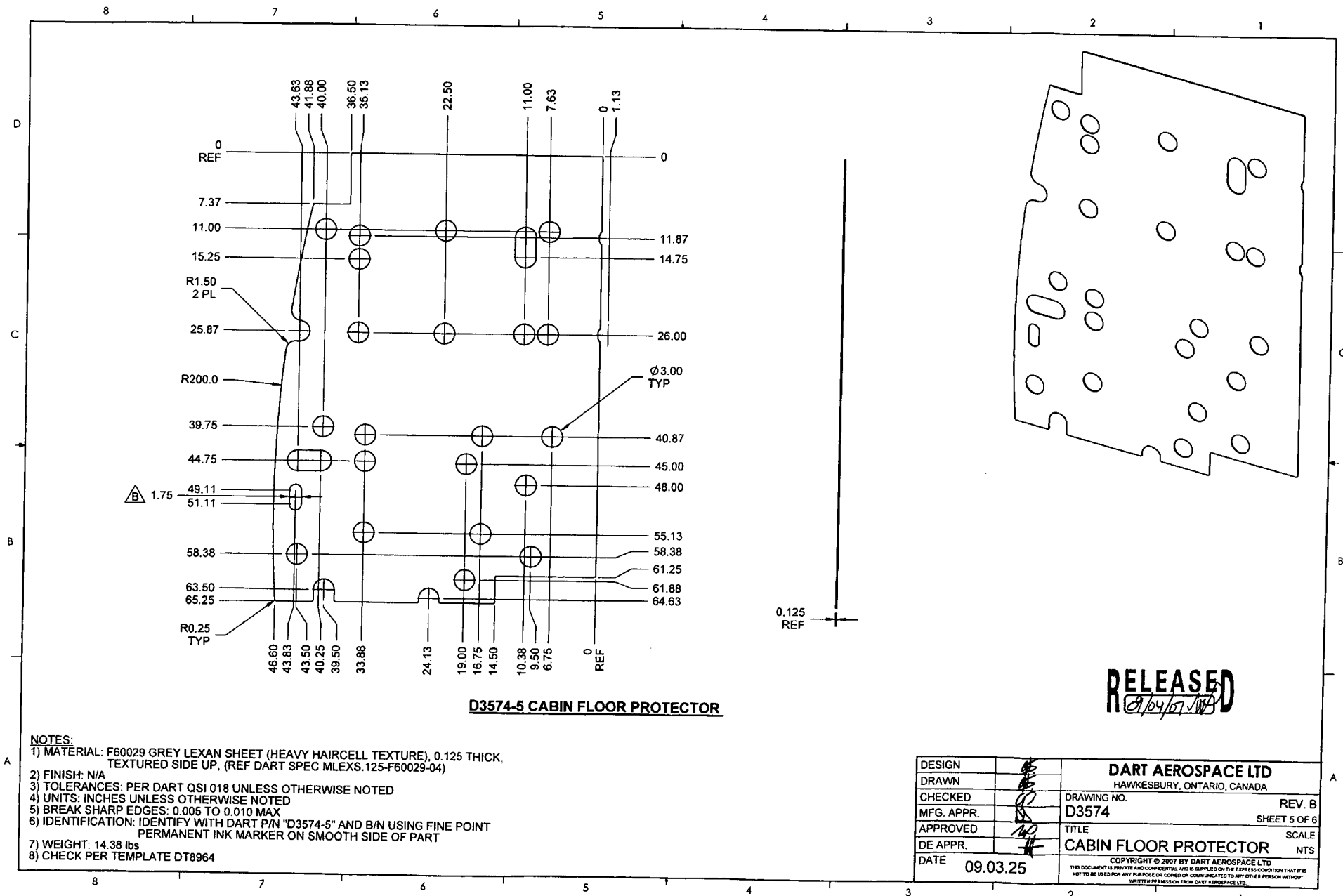


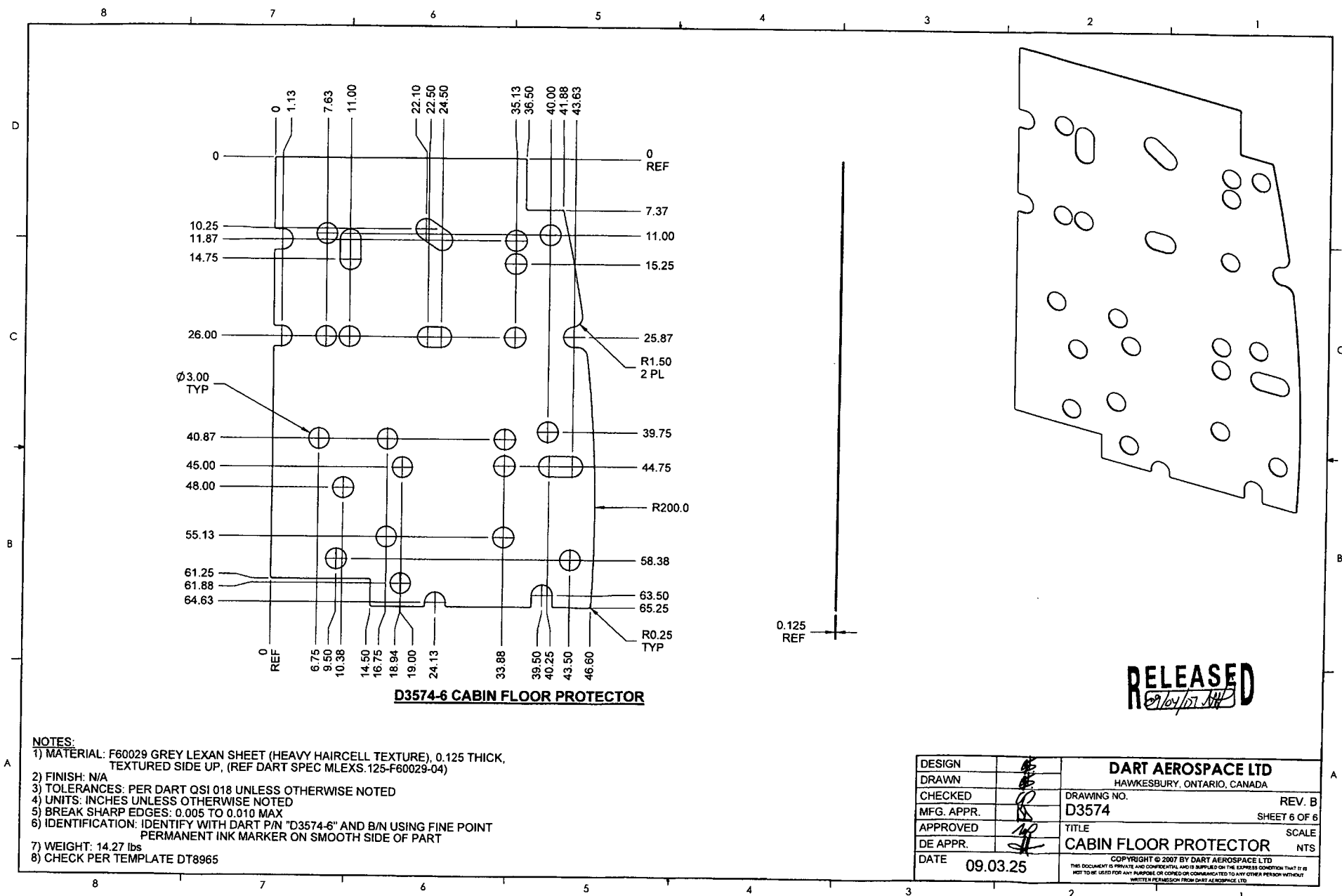
RELEASED
01/07/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3574	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
DATE	09.03.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	135 972
Description: Cabin Floor Protector		Part Number:	D3574-5
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.006	/			
7.37	+/-0.030	7.37	/			
11.00	+/-0.030	11.00	/			
15.25	+/-0.030	15.25	/			
25.87	+/-0.030	25.87	/			
39.75	+/-0.030	39.75	/			
44.75	+/-0.030	44.75	/			
49.11	+/-0.030	49.11	/			
51.11	+/-0.030	51.11	/			
1.75	+/-0.030	1.75	/			
58.38	+/-0.030	58.38	/			
63.50	+/-0.030	63.50	/			
65.25	+/-0.030	65.25	/			
11.87	+/-0.030	11.87	/			
14.75	+/-0.030	14.75	/			
26.00	+/-0.030	26.00	/			
40.87	+/-0.030	40.87	/			
45.00	+/-0.030	45.00	/			
48.00	+/-0.030	48.00	/			
55.13	+/-0.030	55.13	/			
58.38	+/-0.030	58.38	/			
61.25	+/-0.030	61.25	/			
61.88	+/-0.030	61.88	/			
64.63	+/-0.030	64.63	/			
7.63	+/-0.030	7.63	/			
11.00	+/-0.030	11.00	/			
22.50	+/-0.030	22.50	/			
35.13	+/-0.030	35.13	/			
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00	/			
41.88	+/-0.030	41.88	/			
43.63	+/-0.030	43.63	/			
6.75	+/-0.030	6.75	/			

DART AEROSPACE LTD		Work Order: 135972
Description: Cabin Floor Protector		Part Number: D3574-5
Inspection Dwg: D3574	Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.50	+/-0.030	9.50	/		Viper	
10.38	+/-0.030	10.38	/		Tape	
14.50	+/-0.030	14.50	/			
16.75	+/-0.030	16.75	/			
19.00	+/-0.030	19.00	/			
24.13	+/-0.030	24.13	/			
33.88	+/-0.030	33.88	/			
39.50	+/-0.030	39.50	/			
40.25	+/-0.030	40.25	/			
43.50	+/-0.030	43.50	/			
43.83	+/-0.030	43.83	/			
46.60	+/-0.030	46.60	/			
0.125	+/-0.010	.125	/			

Measured by: DL	Audited by: 38 9-89	Prototype Approval:	N/A
Date: 15/09/09	Date: SEP 10 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	08.07.31	1.13 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	